

Work Order ID 104272

104272

Page 1

July-09-13 11:50:38 AM

Item ID: D3335 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spring
 Start Date: 7/09/13 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 7/09/13 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-07-12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3335	Rev D								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>20580</u>								
	Manufacture as per dwg D3335								
	Possible supplier: Victory Springs								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

13-07-15

13/7/25 (10)

13725

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

July-09-13 11:50:38 AM

Item ID: D3335

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spring

Start Date: 7/09/13 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 7/09/13 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

Accept	Qty
--------	-----

Reject
QtyReject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location: ST035 0.00

0.00

130

Packaging

Memo

0.00

Packaging

10x mp. 10. 13-07-26

140

QC21- Final inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/7/2948
MLJ 1307-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
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FAULT CATEGORY

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Picklist Print

July-09-13 11:50:37 AM

Page 1

Work Order ID: 104272

Parent Item: D3335

Parent Item Name: Spring

Start Date: 7/09/13

Required Date: 7/09/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.11.23New issueKJ/JLM
esr B 07.04.04 rev C dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3335-P Spring		Purchased	No			110	f	0.0000	1	10		7/3/20	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

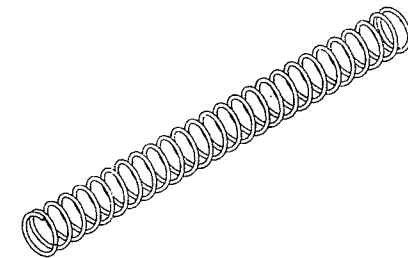
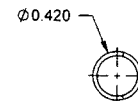
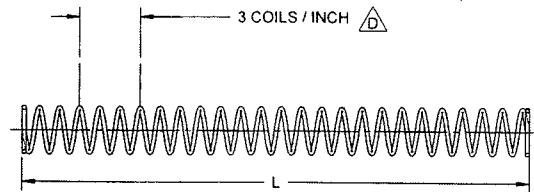
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FAULT CATEGORY

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SPECIFICATION CONTROL DRAWING



D3335-X SPRING

DART P/N	L (in)
D3335-1	4.38
D3335-3	7.63
D3335-5	1.20



NOTES:

- 1) MATERIAL: SPRING STEEL, $\phi 0.035$ WIRE
- 2) FINISH: LPS PROCYON
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) POSSIBLE SUPPLIER: VICTORY SPRINGS, LENGTH REQUIRED: 12"

UNCONTROLLED
SUBJECT TO CHANGE
104272 MJS
13 09-12

RELEASED
9/2/05 WPD

D	ADD 3 COILS / INCH	PH	08.06.05
C	ADDED D3335-5, CHANGED FINISH	RF	05.12.19
B	4.38 WAS 4.13; 7.63 WAS 6.80	MB	05.08.11
A	NEW ISSUE	MB	04.12.07
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	MB	D3335	SHEET 1 OF 1
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	SPRING	NTS
DATE	08.06.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO20580**

Purchase Order Date 7/15/2013

PO Print Date 7/15/2013

Page Number 1 of 1

Order From :

VC-VIC002

Ship To : DART AEROSPACE LTD

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 866 230 5312

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Brigitte Golden

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	List Price	Disc %	Discounted Unit Price	Extended Price
1	D3335-P As per DWG: D3335 Rev:D B104272	Spring	7/15/2013 Yes 7/15/2013		10.00 f				\$152.80

Line Total: \$152.80

PO Total: \$152.80

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.
No substitution or deviation without consent.
Certificate of Conformity or Material Certification required - YES NO

Change Nbr:

2

Change Date:

7/15/2013

**PACKING SLIP**

27574

#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

BILL TO: Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A, 1K7

SHIP TO:

DATE		ORDER No.		SHIP VIA	
24-Jul-13		PO20580		FedEx	
QUANTITY	DESCRIPTION			UNIT	AMOUNT
10	D3335-P Compression Spring				
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd	DATE: 7/24/2013
PART/DRAWING #: D3335-P	PO # PO020580
DESCR: 12" Lenth Compression Spring	QUANTITY: 10

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS302	Yes	
Material diameter	0.035	0.035	
Coil I.D.			
Coil O.D.	0.420" +/- 0.012"	0.428"/ 0.430"	
Pitch	0.330"	0.323"	
Free Length	12"	12.3"	
End Type	Closed, Not ground	Yes	

COMMENTS

Mill Certificate attached: No
Material Heat Number:

Inspected by: *Chris Burrowes*